



Dart Aerospace Ltd.
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RB877206-5-16
Job Sheet 194165


Part No: RB877206-5-16 **Job Qty:** 4 pcs
Part Name: Swashplate Bearing Install/Removal Set

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 4/26/19 **Job Tracking No:**
Due Date: 6/14/19 **Created By:** Marie Lajeunesse
Type: Stock **Description:** SIOP
Note: DWG RB877206-5 REV 4A IPP REV A 18.02.22 NEW ISSUE FK VERIFY DP
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	4 pcs	6/14/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	4 pcs	6/14/19		0.00	0.00	QC 5 - 10		DAS JUL 24 2019 409-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	4 pcs	6/14/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S199809

Part: RB877206-5-16
Job No: 194165
Serial No/Batch: S199809
Revision: 4A
Inspector:
Exp Date:
Instructions:

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CANADA
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Date: 07/23/19

		Packaging 3 - 8 - B4B		
		Packaging 3 - 9 - B4B		
		Packaging 3 - 10 - B4B		MLL
		Packaging 3 - 11 - B4B		
		Packaging 3 - 12 - B4B		
		Packaging 3 - 13 - B4B		
		Packaging 3 - 14 - B4B		
		Packaging 3 - 15 - B4B		
		Packaging 3 - 16 - B4B		
		Packaging 3 - 17 - B4B		
		Packaging 3 - 18 - B4B		
		Packaging 3 - 19 - B4B		
		Packaging 3 - 20 - B4B		
		Packaging 3 - 21 - B4B		
		Packaging 3 - 22 - B4B		
		Packaging 3 - 23 - B4B		
		Packaging 3 - 24 - B4B		
		Packaging 3 - 25 - B4B		
		Packaging 3 - 26 - B4B		
		Packaging 3 - 27 - B4B		
		Packaging 3 - 28 - B4B		
		Packaging 3 - 29 - B4B		
		Packaging 3 - 30 - B4B		
		Packaging 3 - 31 - B4B		
		Packaging 3 - 32 - B4B		
		Packaging 3 - 33 - B4B		
		Packaging 3 - 34 - B4B		
		Packaging 3 - 35 - B4B		
		Packaging 3 - 36 - B4B		DAG
140 QC 21 - FG	4 pcs	6/14/19	0.00 0.00	QC 21 - FG - 21
				QC 21 - FG - 70
				QC 21 - SA - 53

Part Op 100 - Small Fab-9 (Small Fab) 1-Assemble as per DWG. Sheet 1.

Descriptions: 110 - QC5 (QC5- Inspect part completeness to step on W/O)

130 - Packaging3-2 (Identify as per dwg & Stock Location:) Bag and tag

140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
97431A310	Snap Ring	4 Ea (1 ea)	100-Small Fab - 1	5093333
NTA-512	Bearing	4 Ea (1 ea)	100-Small Fab - 1	5052540
RB877206-5-17	R & I Adapter	4 pcs (1 ea)	100-Small Fab - 1	5135091
RB877206-5-21	Cap	4 pcs (1 ea)	100-Small Fab - 1	5196236
RB877206-5-27	Bolt	4 pcs (1 ea)	100-Small Fab - 1	5191306
TRA-512	Washer	8 Ea (2 ea)	100-Small Fab - 1	515060994
				34 5093404

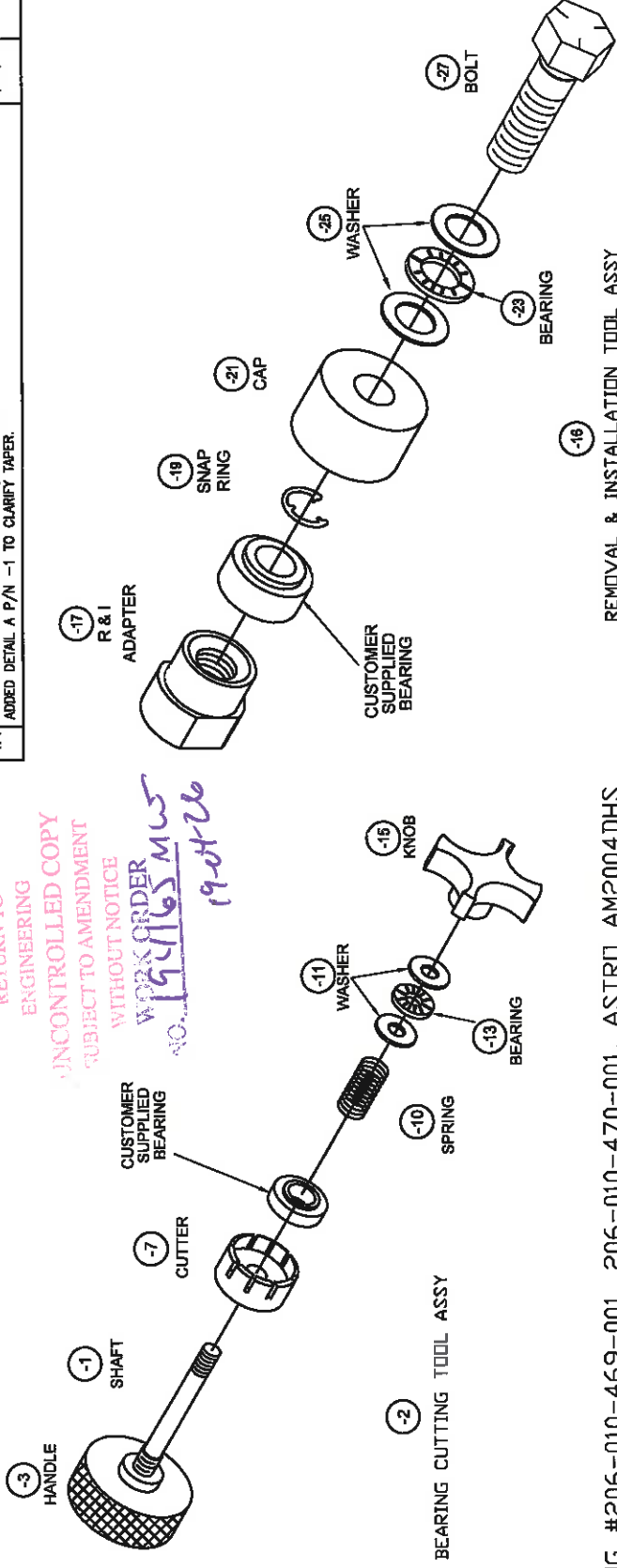
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	97431A310	4	100	0
	NTA-512	4	18	0
	RB877206-5-17	4	9	0
	RB877206-5-21	4	0	0
	RB877206-5-27	4	0	0
	TRA-512	8	35	0

Part Specifications				
Specifications could not be found.				

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WORK ORDER
NO. 19-1165 MWS
19-01-26



NOTE:
BEARING #206-010-469-001, 206-010-470-001, ASTRO AM2004DHS

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
1		-1	1	SHAFT	STRESS PROOF	Ø3/4 x 4	2
	X	-2	1	BEARING CUTTER TOOL ASSY			1
1		-3	1	HANDLE	6061 T6	Ø2 x 3/4	2
1		-7	1	CUTTER	01	Ø1 x 5/8	3
1	B/O	-10	1	SPRING	5/16 x 2 (EUGENE FASTNER #16)		1
2	B/O	-11	1	WASHER	TRA-512 (APPLIED INDUSTRIAL)		1
1	B/O	-13	1	BEARING	NTA512 (APPLIED INDUSTRIAL)		1
1	B/O	-15	1	KNOB	DK-55 (REID TOOL)		1
	X	-16	1	REMOVAL & INSTALLATION TOOL ASSY			1
1		-17	1	R&I ADAPTER	STRESS PROOF	Ø1-1/4 x 1-1/4	4
1	B/O	-19	1	SNAP RING	Ø5/16 EXTERNAL		1
1		-21	1	CAP	Ø1-1/2 x 1		4
1	B/O	-23	1	BEARING	NTA512 (APPLIED INDUSTRIAL)		1
2	B/O	-25	1	WASHER	TRA-512 (APPLIED INDUSTRIAL)		1
1		-27	1	BOLT	5/16-24 UNF x 3 MODIFY		4
ASSY QTY	-16	-2					

RED BARN MACHINE
BEARING CUTTER

DWG NO. RB877206-5 REV 4A

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS FRACTIONS ± 1/32
XXX ± .005
XX ± .01
X ± .1
FINISH
USED ON MODEL
BELL
SCALE NTS DATE 6-28-01 SHEET 1 of 4

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Quality ☐									
Date :	Sequence #:	QTY Affected :		MRB (QSI042)									
Description Work Order Deviation				Disposition									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY									
				Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
				Other/Details:									
				Completed By									
				Lead hand / Supervisor									
				QC / QA Coordinator									